

Work Order ID 60638

Thursday, July 15, 2010 10:35:26 AM

Page 1

Item ID: D412-630-033

Accept

Revision ID:

Item Name: Heli Access Step LH Folding

Start Date: 7/15/2010 Start Qty: 2.00

Required Date: 7/22/2010 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & create labels per PPP D412-630-033 CHG003

110

0.00



Small Fab

Small Fab

Small Fab

Memo

0.00

Assemble as per dwg D412-630 p.14 ☐ Coat all hardware with LPS3 rust inhibitor ☐ A/R LPS3 batch: 970429 ☐ COAT exposed HARDWARE WITH LPS PROCYON ☐ A/R LPS PROCYON BATCH: M114576

120

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

H for BG 10-9-01

EP 01/09/01 (2)

2 100638-01
Identical to 60638 for PKing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60638

Thursday, July 15, 2010 10:35:26 AM



Page 2

Item ID: D412-630-033

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step LH Folding

Start Date: 7/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Pick Kit	0.00							
Packaging	Memo	0.00				10/9/2		sl	20
Packaging									
140 	QC4- 100% Inspect kits for completeness	0.00				2			
QC	Memo	0.00							100% kits separated E.T.D.'d
Quality Control									
150 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-033								
	Location: _____								
	PPP Rev: <u>A</u>								

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Item ID: D412-630-033

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step LH Folding

Start Date: 7/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/03 *[Signature]*

CL 10/9/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 60638

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding





Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-11-08 JLM
IPP rev B ecn 1019, added d2807-041 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-107  Clevis		Manufactured	No			110	Each	25.0000	1	2		7/10/09/01	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST004				25					
				40274				7					
				46634				18					
D2803-041  Bracket Assembly		Manufactured	No			110	Each	6.0000	1	2		7/10/09/01	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST147				6					
				46639				6					
D2804-041  Bracket Assembly		Manufactured	No			110	Each	4.0000	1	2		7/10/09/01	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST150				4					
				46843				4					
D2807-041  Door prop		Manufactured	No			110	Each	11.0000	2	4		7/10/09/01	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST025				11					
				55108				1					
				56882				10					

B60540 (400)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 60638

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

D2813
Washer

Manufactured No

110 Each

23.0000

2

4

Location

Loc Qty

Loc Code

ST025

23

14401

11

46332

12



EP 10/09/01
B61051 (IX)

D3562-041
Step Assembly, LH

Manufactured No

110 Each

1.0000

1

2

Location

Loc Qty

Loc Code

FG110

1

54963

1



EP 10/09/01
B60634 (2x)

D3395-1
Bushing

Manufactured No

110 Each

20.0000

4

8

Location

Loc Qty

Loc Code

ST055

20

46616

20



EP 10/09/01

AN3C21A
BOLT

Purchased No

110 Each

64.0000

2

4

Location

Loc Qty

Loc Code

ST352

64

109148

64



EP 10/09/01
4

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Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Work Order ID: 60638

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

AN8C16

Purchased

No

110

Each

83.0000

2

4



Bolt

Location

Loc Qty

Loc Code

ST345

83

105969

23

106066

60



Ep 10/09/01

4

AN310C8

Purchased

No

110

Each

39.0000

2

4



Nut

Location

Loc Qty

Loc Code

ST324

39

109148

5

111279

4

111819

30



Ep 10/09/01

4

MS24665-302

Purchased

No

110

Each

53.0000

6

4



Cotter Pin

Location

Loc Qty

Loc Code

ST309

53

113644

53



Ep 10/09/01

2

NAS1515H3

Purchased

No

110

Each

136.0000

4

8



Washer

Location

Loc Qty

Loc Code

ST277

136

111268

136



Ep 10/09/01

8

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 4

Work Order ID: 60638

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

NAS1515H5L



WASHER

Purchased

No

110

Each

156.0000

4

8



Ep 10/09/01

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

116

108964

16

111359

100

4
4

NAS1515H8



Washer

Purchased

No

110

Each

338.0000

4

8



Ep 10/09/01

Location

Loc Qty

Loc Code

ST278

338

111275

138

111411

200

8

MS21043-3



Nut

Purchased

No

110

Each

3,047.000

4

8



Ep 10/09/01

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2971

112314

2971

8

MS24693-C280



Screw

Purchased

No

110

Each

27.0000

2

4



Ep 10/09/01

Location

Loc Qty

Loc Code

ST318

27

111279

27

4

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 5

Work Order ID: 60638

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

D2806-1
Bushing

Manufactured No

140 Each

27.0000

2 4
10/9/25

Location

Loc Qty

Loc Code

ST025

27

14080

2

46609

25

Manufactured No

140 Each

27.0000

2 4
10/9/25

Location

Loc Qty

Loc Code

ST025

27

46737

27

Manufactured No

140 Each

10.0000

1 2
10/9/25

Location

Loc Qty

Loc Code

ST265

10

52034

10

Manufactured No

140 Each

56.0000

2 4
10/9/25

Location

Loc Qty

Loc Code

ST055

56

46748

56

D2810-5
Strut

D3396-1
Spacer

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 60638

Parent Item: D412-630-033

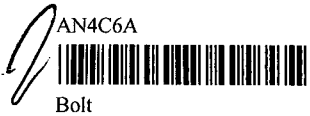
Parent Item Name: Heli Access Step LH Folding

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00



Purchased No 140 Each 451.0000

1 2
M111295 10/1/25

Location	Loc Qty	Loc Code
FG	4	
103344	4	
ST356	447	
113121	247	
115016	200	



Purchased No 140 Each 120.0000

1 2
10/9/25

Location	Loc Qty	Loc Code
ST356	120	
106302	5	
111295	35	
112243	50	
114523	30	



Purchased No 140 Each 93.0000

2 4 1x 1x
M109/48 M105/25
10/1/25

Location	Loc Qty	Loc Code
ST339	93	
111819	93	

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 7

Work Order ID: 60638

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

AN44C7A

Purchased

No

140

Each

92.0000

Eyebolt

Location

Loc Qty

Loc Code

ST362

92

109013

47

111279

3

111308

40

111503

2

AN4C15A

Purchased

No

140

Each

124.0000

Bolt

Location

Loc Qty

Loc Code

ST358

124

111819

1

113595

11

113603

10

114330

2

114442

50

114523

50

MAS1515H4

Purchased

No

140

Each

139.0000

Washer

Location

Loc Qty

Loc Code

ST277

139

111294

41

111525

98

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 8

Work Order ID: 60638

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

NAS1515H5
Washer

Purchased No 140 Each 241.0000 7



14
10/9/25

Location Loc Qty Loc Code

FG 44
103286 17
103691 27
ST277 197
109430 197

MS21043-4
Nut

Purchased No 140 Each 1,283.0000 4



8
10/9/25

Location Loc Qty Loc Code

FG 40
104603 40
ST301 1243
112492 25
113069 8
114348 410
114523 500
114784 300

MS21043-5
Nut

Purchased No 140 Each 612.0000 3



6 (4x) 2x
M109335 M110180
10/9/25

Location Loc Qty Loc Code

ST301 612
111819 112
112314 500

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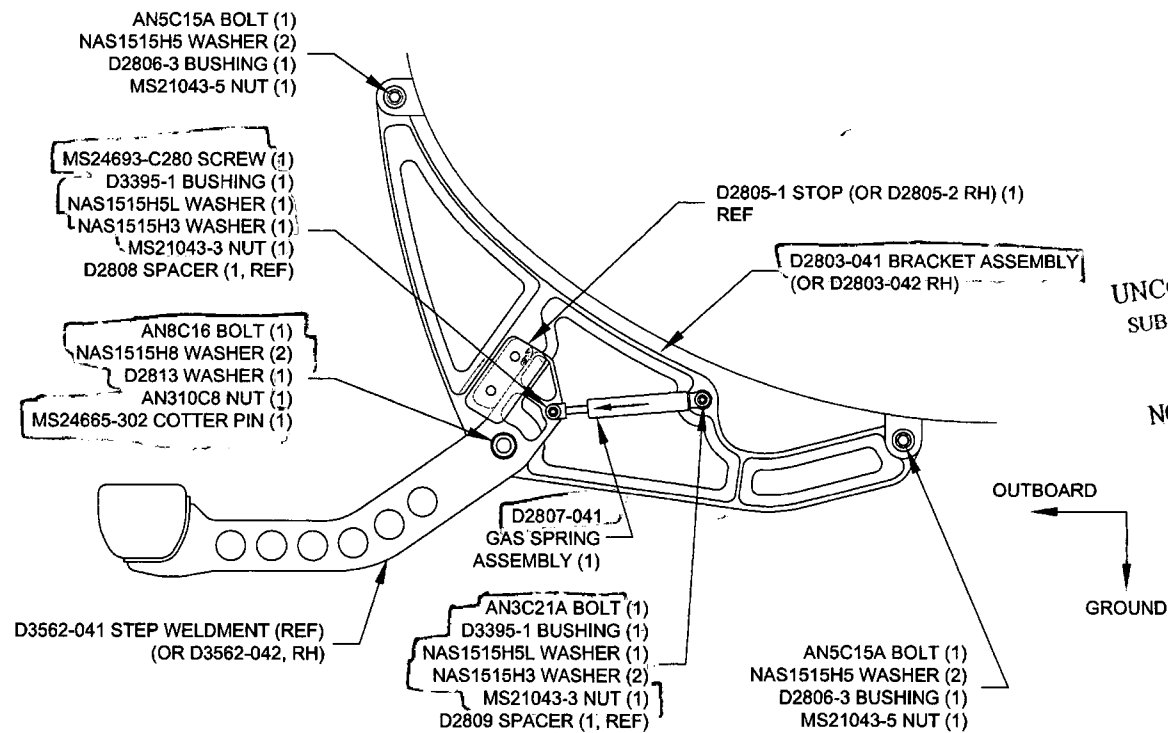
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D412-630-033/-034 Heli-Access-Step™ Installation



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60638
2810-7-15

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

AN4C15A BOLT (1)
NAS1515H4 WASHER (2)
D2806-1 BUSHING (1)
MS21043-4 NUT (1)

D2805-1 STOP (OR D2805-2 RH) (1)
AN3C16A BOLT (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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